

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022337**Date Inspected:** 23-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Wang Ziong Ping, CWI Wang Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3020BB

Weld No: 065

Welder: 067609

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W

PCMK: SEG3020BB

Weld No: 047

Welder: 051348

WPS-B-P-2214-TC-U4b-FCM-1

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Components; OBG 13CW
PCMK: DP3153-001
Weld No: 128
Welder: 066129
WPS-B-P-2114-TC-U4b-FCM-1

Components; OBG 13CW
PCMK: DP3153-001
Weld No: 139
Welder: 067572
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13CW
PCMK: DP3153-001
Weld No: 134
Welder: 067829
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13BW
PCMK: DP3133
Weld No: 019,020
Welder: 066674
WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Ziong Ping, CWI Wang Jun.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13CW
PCMK: AH3003
Weld No: 002
Welder: 047866
WPS-B-T-2231-ESAB

Components; OBG 13BW
PCMK: SEG3014G
Weld No: 009
Welder: 201583
WPS-B-T-2233-ESAB

Components; OBG 13BW (see photo below)

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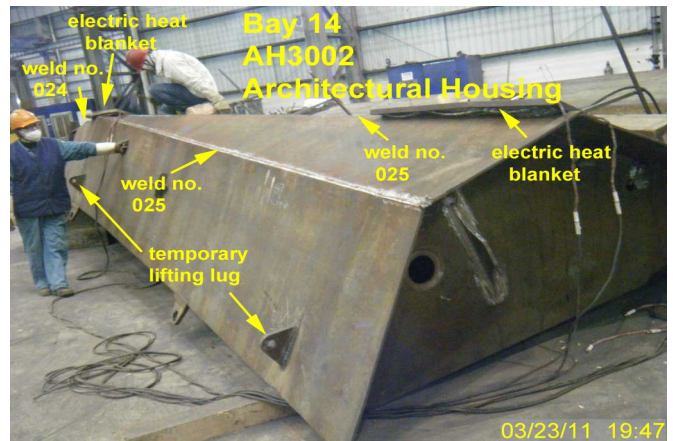
PCMK: AH3002
Weld No: 027
Welder: 068445
WPS-B-T-2232-ESAB

Components; OBG 13CW
PCMK: SEG3015J
Weld No: 009
Welder: 045143
WPS-B-T-2233-ESAB

This Caltrans QA Inspector observed ZPMC performing match drilling in splice plates X4075A.
(see photo below)

This QA Inspector performed random document review of "Team China request for information (TC-RFI)" document #TC-RFI-0196R0. This RFI addresses OBG 14 one-sided/one-weld fit lugs for vertical plate stiffeners at floorbeam web plates. This QA Inspector performed random visual inspections of the welds listed in the RFI and observed ZPMC appears to be in process for the welds referenced in the RFI. This QA Inspector took random photographs of the welds and copies of the photographs have been placed in "TC-RFI Documentation" folder located on Team China common Z drive. (see photo below)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

“No relevant conversations.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer